

Date: Tuesday, 28/04/2009 12:38:19 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 47564			Part Number	: D2571	
Estimate Number	: 10530			Drawing Number	: D2571 REV E	
P.O. Number	:			Project Number	: N/A	
This Issue	: 28/04/2009		S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 07/05/2009 Qty: 8 Um: Each
Previous Run	: 47247					
Written By	:					
Checked & Approved By	: <u>JUD 09.04.29</u>					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B46412</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>47564</u> Double check by: <u>SL</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

8P 09/06/15

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(X8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

1MP 09/06/15

7.0 POWDER COATING

POWDER COATING



MU11472

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:55 AM

OVEN TEMPERATURE: 320°F

FINISH TIME:

11:25 AM 9/1 09-06-15

(X5)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 09/06/15

(8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(8)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/33

9/c/14

SO

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/17 H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-16

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	47564
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.000		
F	0.490	0.510		.502	.501	.509	.499		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.498	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.565	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.485	1.485	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.126	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.127	.124	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.239	.238		
W	0.115	0.135		.127	.126	.124	.124		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.365	.365	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.629	.628	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.249	.247	.248		
AE	1.375	1.395		1.387	1.387	1.388	1.389		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.251	.249	.248	.249		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL	Audited by:	BP
Date:	09/06/13	Date:	09/06/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

W/O:		WORK ORDER CHANGES					
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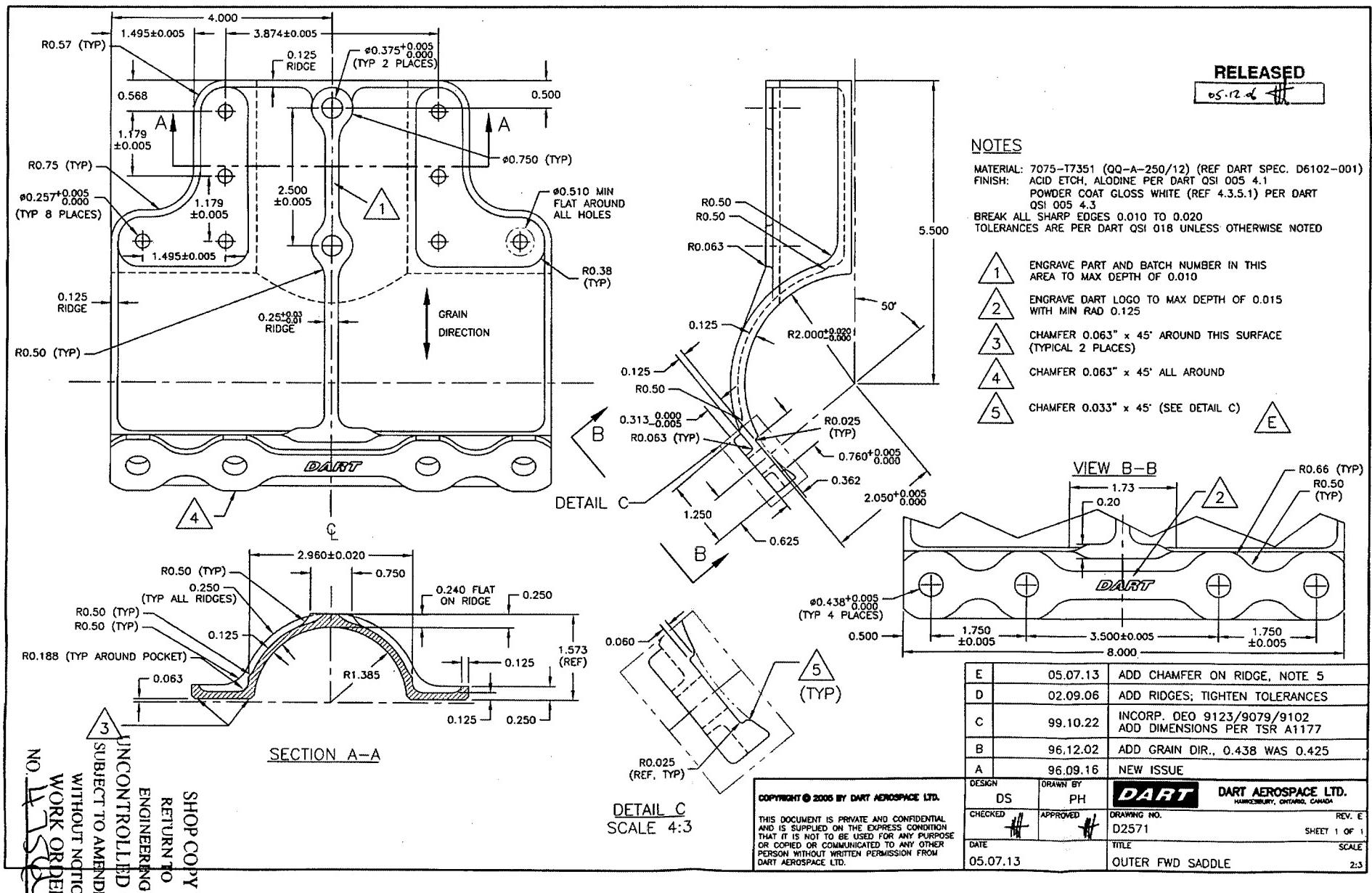
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